

Date: Wednesday, 12/11/2008 1:30:53 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001, Dart Helicopters Services

Job Number : 43339

Estimate Number : 12485

P.O. Number :

This Issue : 12/11/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / /

Previous Run : 43338

Written By : JLD 08.11.12

Checked & Approved By

Comment : Est Rev:A New Issue 06-07-05 JLM
 Est Rev:B Update qty of MS21042L5 06-09-12 KJ
 Est Rev:C Rev B 07-11-15 DD
 Est Rev D Combined manufacturing 08.04.02 EC verified by:
 DD
 Est Rev:E 08-06-24 revD as per dwg DD verified by:EC

Drawing Name : 350/355 AS X-TUBE FWD

Part Number : D350748101

Drawing Number : N/A

Project Number : N/A

Drawing Revision : D

Material :

Due Date : 02/12/2008 Qty: 1 Um: Each

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL

Comment: Photocopy bluefile & type labels per PPPD350-748-101 CHG001

2.0 D350748141TRN Crosstube Turning Detail

Comment: Qty 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 CROSSTUBE TURNING DETAIL
 batch 6-40419

3.0 BENDING BENDING MACHINE - SKIDTUBES

Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

4.0 QC15 DIMENSIONAL CHECK OF X-TUBES

Comment: DIMENSIONAL CHECK OF X-TUBES

5.0 CROSSTUBES CROSSTUBES RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 A/B & C Drill Jigs,
 Set-up drill table as per QSI 010

2-Deburr

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:30:53 PM
User: Julie Dawson

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43339

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Engrave Part # and Batch # as per Dwg D350-748-141

RT / mb 08-11-21

4-Remove all marks from tube within limits of D350-748-141

- AWM 8-11-26

5- Apply a light coat of LPS3 on the interior of tube

Batch: M109539

- FL 08/11/27

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CHECK 10 DEG HOLES WITH DT8876E(EUROCOPTER CLAMP)

08/11/27

7.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7700

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

08/11/27

①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

RT 08-12-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date: Wednesday, 12/11/2008 1:30:53 PM
User: Julie Dawson

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43339

Part Number: D350748101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC14	INSPECT SPRAY PAINT
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ml 08 12 24



①

Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

12.0	D35021	Support
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SUPPORT

Batch: 42968

ml 08 12 29

13.0	D2856400	Abrasion Strip
------	----------	----------------



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

ml 08 12 29

14.0	ALS41032225	Insert
------	-------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: 109817

ml 08 12 29

15.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 105442

ml 08 12 29

16.0	MS2192020	Clamp (per MIL-DTL-8783C)
------	-----------	---------------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 109715

ml 08 12 29

17.0	MS27039110	Screw
------	------------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

ml 08 12 29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43339

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

ml 08 12 29 ①

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-12-30 ①

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D35001

Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

350 SADDLE

Batch: 41555

SP

22.0

D35011

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

BUSHING

Batch: 139726

SP

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Batch: 1109545

SP

24.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

bolt

Batch: 1109632

8/12/30

①

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43339

Part Number: D350748101

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

25.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109752

SP

26.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M109249

SP

27.0	AN960JD516	Washer
------	------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M109752

SP

28.0	MS21042L4	Nut
------	-----------	-----



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M108145

SP

29.0	MS21042L5	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M109297

8/10/30

SP

30.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

08-12-30 (1)

31.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-101

Location: A

PPP Rev: A

9/1/5

SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE FWD

Job Number: 43339

Part Number: D350748101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

09/01/06

Job Completion



MF 08+
09-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

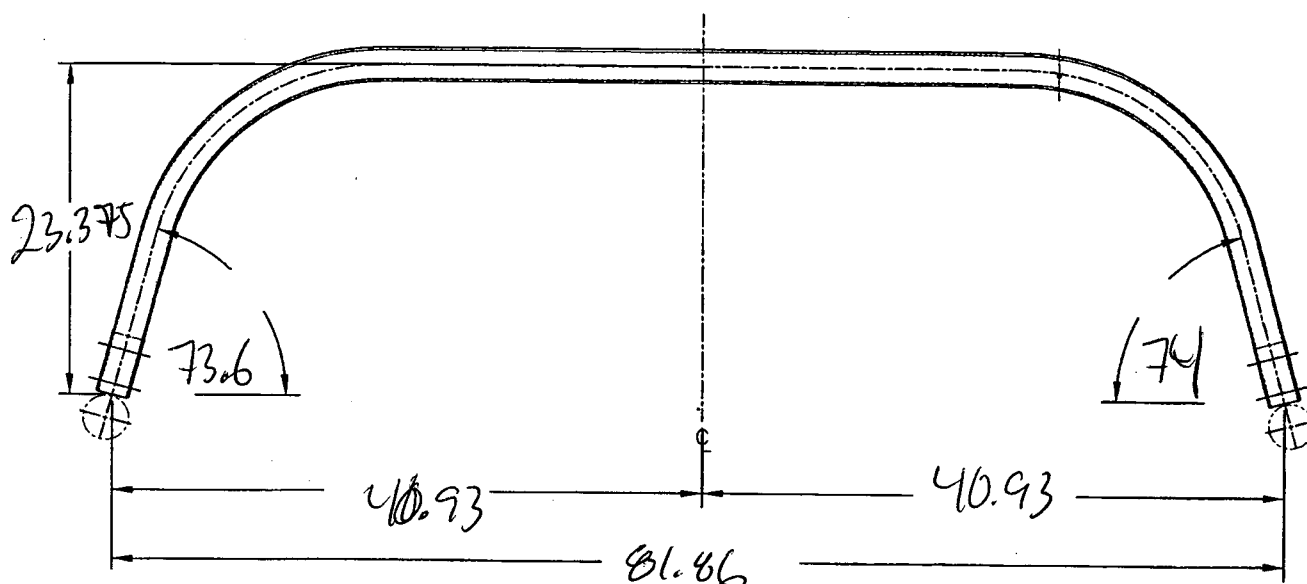
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	43339
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments

QC15 Inspection	<i>[Signature]</i>
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED06.10.31 *[Signature]*

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27 ± 0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR $\varnothing 0.297$ HOLE.

UNDER REVIEW!07.02.16 *[Signature]*CUT FROM REVISION
07.07.16 *[Signature]*ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 23339

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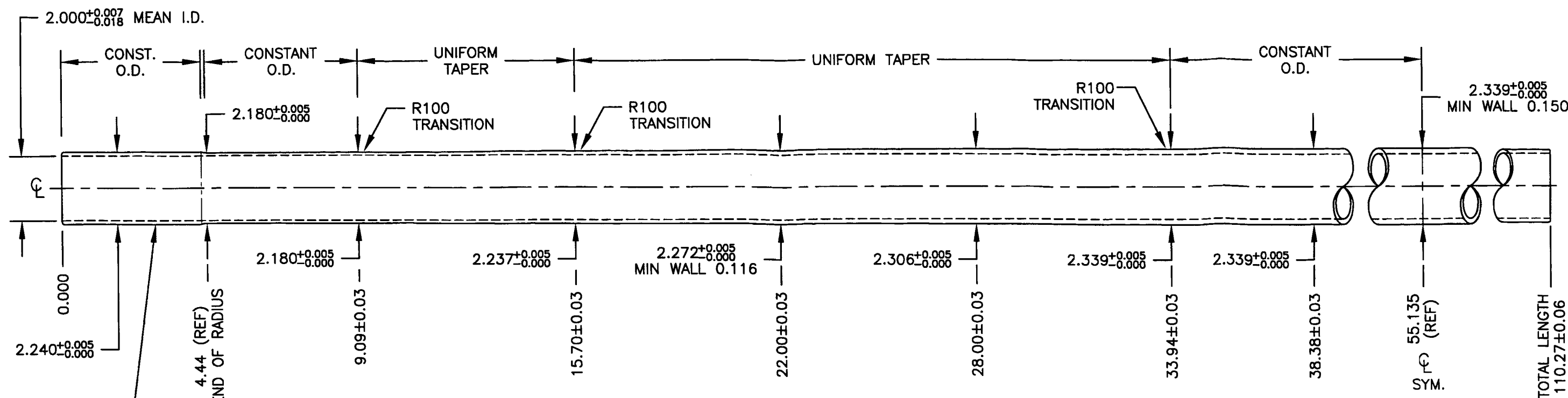
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

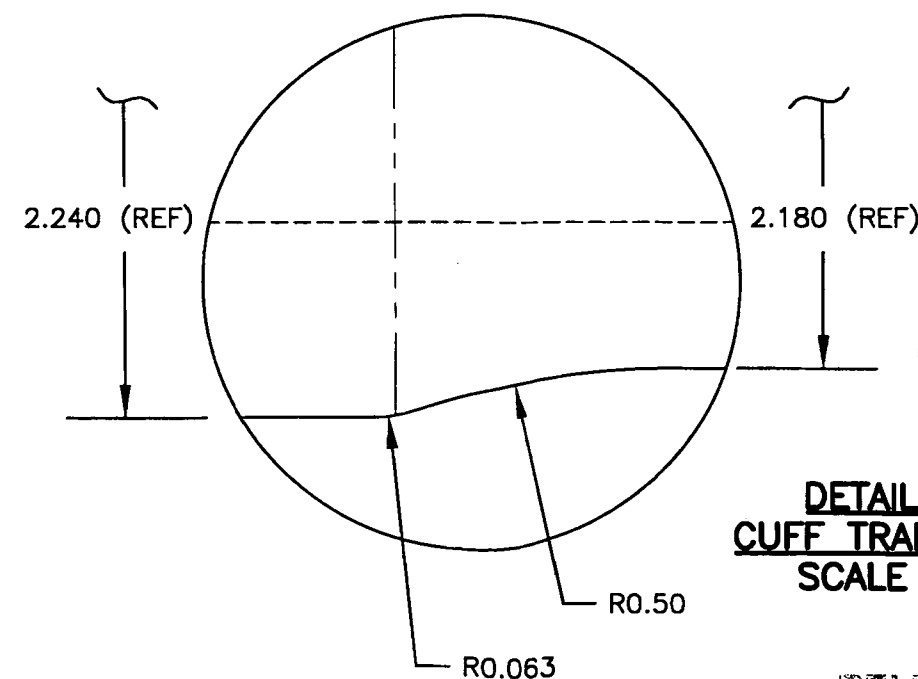
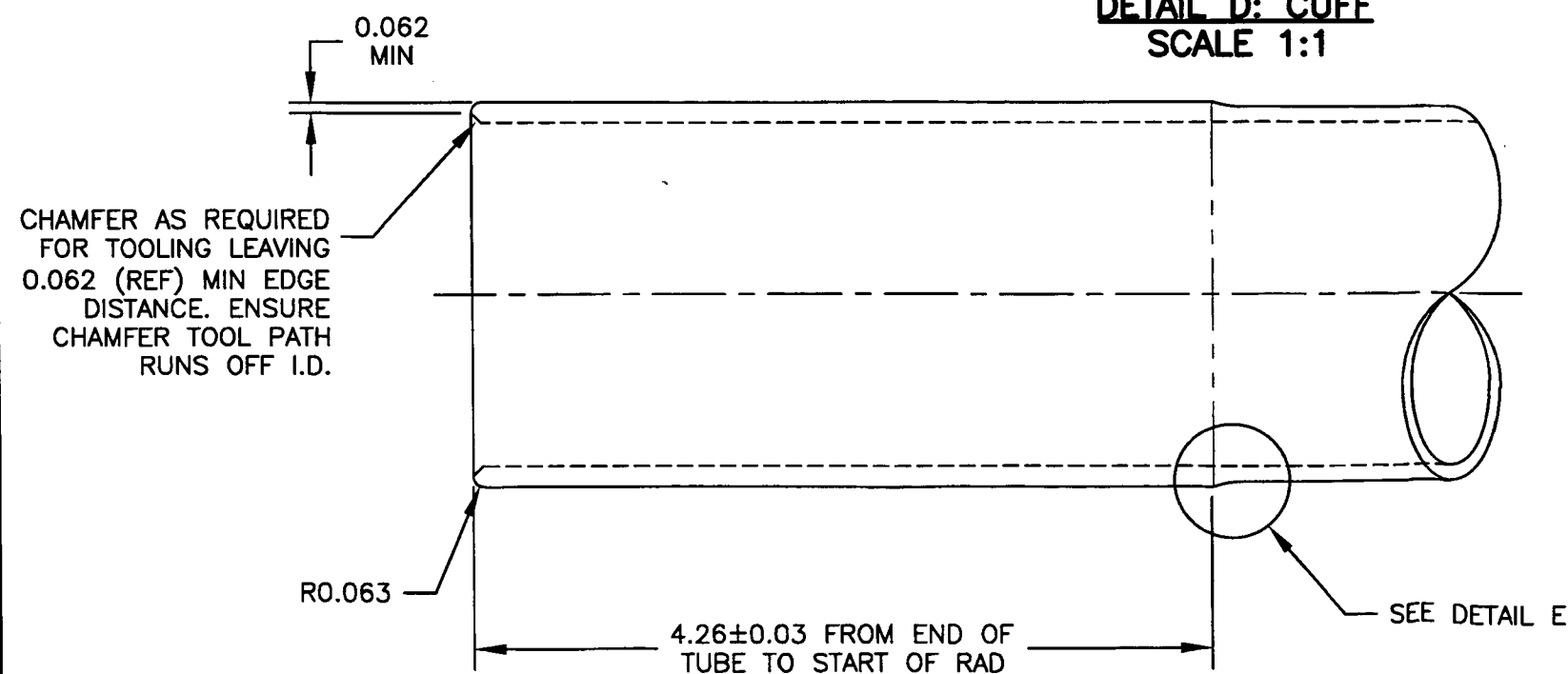
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



D350-748-141 MACHINING DETAIL

DETAIL D: CUFF SCALE 1:1



UNDER REVIEW

**DETAIL E:
CUFF TRANSITION
SCALE 9:1**

RELEASED

06.10.31

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DESIGN QP	DRAWN BY QP	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D350-748-141	REV. D SHEET 3 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:3

Packing Slip



Cadorath Plating Co. Ltd.

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

42387

Sold To:

Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

Ship To:

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
00067700	Dec-08-2008	NET 30 DAYS	10071 6547 RT0001		Dec-17-2008

Item #	Qty	P/N & Description	
1	1 EA	SKID	S/N B43336
		P/N d350-748-101	W/O 82376
2	1 EA	SKID	S/N B43337
		P/N d350-748-101	W/O 82377
3	1 EA	SKID	S/N B43339
		P/N d350-748-101	W/O 82378
4	1 EA	SKID	S/N B42538
		P/N d350-748-101	W/O 82379

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Dec-17-2008

CONSIGNEE TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 82378

INVOICE #: 42387

**CONTRACT OR
PURCHASE ORDER # 00007700**

DESCRIPTION: SKID

QTY 1

P/N # d350-748-101

S/N # B43339

**STRESS RELIEF BAKE @ 375 FOR 5 HRS HEAT CHART # 9921. MPI
INSPECTED IAW ASTM E 1444. CADMIUM PLATED IAW AMS-QQ-P-
416B, TYPE 2 YELLOW, CLASS 2. BAKE HEAT CHART # 9967.**

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:



A large, stylized handwritten signature in black ink.

Date: Thursday, 13/11/2008 10:05:56 AM
 User: Julie Dawson

Process Sheet

49

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/355 AS X-TUBE FWD
 Job Number : 43339
 Estimate Number : 12485
 P.O. Number :
 This Issue : 13/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350748101
 First Issue : 12/11/2008 Type : CROSSTUBES Drawing Number : N/A
 Previous Run : 43338 Drawing Revision : D
 Material :
 Due Date : 02/12/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-07-05 JLM
 Est Rev:B Update qty of MS21042L5 06-09-12 KJ
 Est Rev:C Rev B 07-11-15 DD
 Est Rev D Combined manufacturing 08.04.02 EC verified by:
 DD
 Est Rev:E 08-06-24 revD as per dwg DD verified by:EC

REFERENCE ONLY

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 08.12.08



Comment: Photocopy bluefile & type labels per PPPD350-748-101 CHG001

2.0 D350748141TRN Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 CROSSTUBE TURNING DETAIL
 batch _____

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE
 Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT _____

Job Completion

